



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C10-4-11
Job Sheet 176089



Part No: C10-4-11

Job Qty: 20 ea

Part Name: Lock Shaft



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 4/17/18

Job Tracking No:

Due Date: 4/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C10-4-11 Rev 2A IPP Rev A 18.04.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		4/19/18	0.00	0.00	Start Up Machining-3		JB 18.07.09
110	Lathe Conv	20 pcs		4/20/18	0.00	4.00	Lathe Conv-2		JB 18.07.09
120	QC	20 pcs		4/20/18	0.00	0.00	QC2 Machining-4		JB 18.07.09
130	QC	20 pcs		4/20/18	0.00	0.00	QC8 Machining-4		JB 18.07.10
135	Outsource	20 pcs		4/20/18	0.00	0.00	Outsource1		
140	Outsource	20 pcs		4/20/18	0.00	0.00	Outsource15		
150	Packaging	20 pcs		4/20/18	0.00	0.00	Packaging2		2018-7-11 GA-Ala
160	QC	20 pcs		4/20/18	0.00	0.00	QC6		DAB
210	Packaging	20 pcs		4/20/18	0.00	0.00	Packaging3-1		21 JUL 11 2018
220	QC21-SA	20 Ea		4/20/18	0.00	0.00	QC21		21 JUL 11 2018

Part Op 110 - 1-Machine as per DWG. 2-Debur

Descriptions: 135 - 1--Issue P/O to Metcore ; P/O _____ RC 44-46 2-Bead blast 3- Certificate of Conformity is required

NOTE DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***

140 - -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R0.625	17-4 SS H900 Round Bar 0.625"	3.6600 ft (.183 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R0.625	4	11	0

Part Specifications

Specifications could not be found.

INSPECTION SHEET

[illegible]

Measured by: JB	Checked by:	QC Inspector:
Date: 18.08.09	Date:	Date:

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

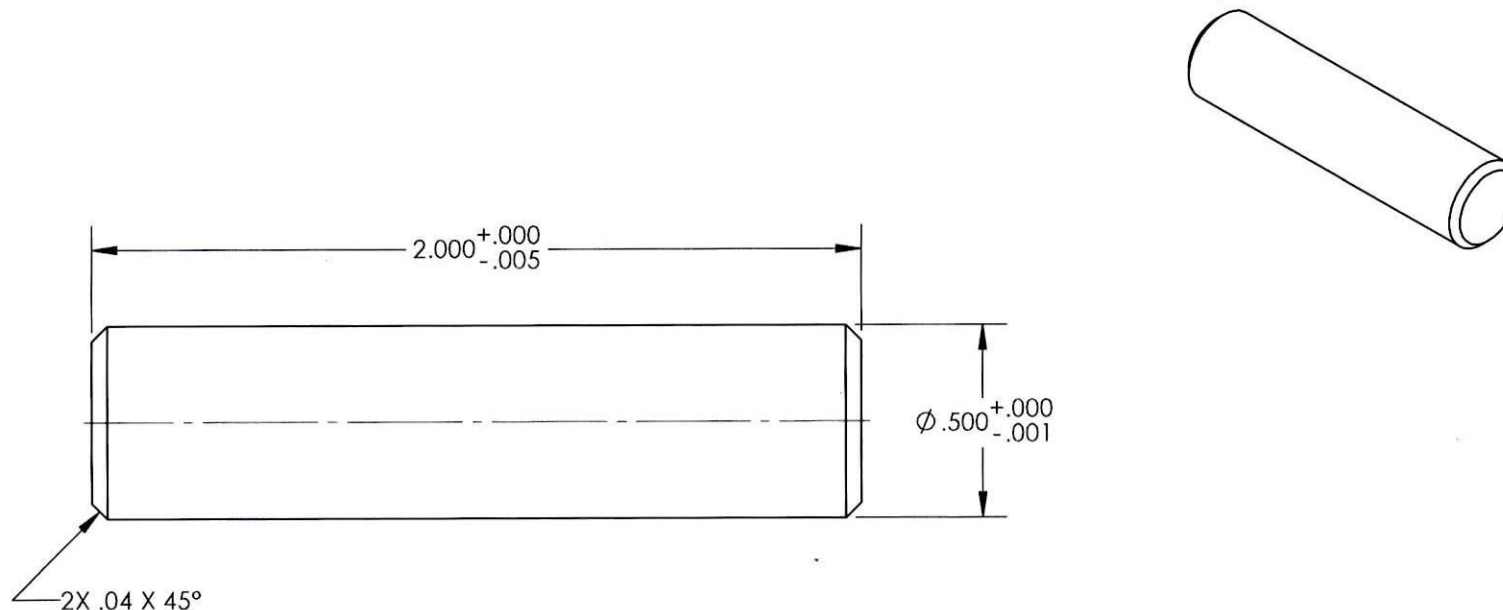
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM.	4/30/2013	CFS	
2A	14-0115	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE.	8/8/2014	DPD	RW



NOTES:

1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.
2. BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOCK SHAFT	
DWG NO. C10-4-11	REV 2A
MAT'L 4140	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XX ± .005 FRACTIONS ± 1/8	HEAT TREAT HRC 44-46
.XX ± .01 ANGLES ± 5°	FINISH SEE NOTE 1
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 4/26/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C10-4-11	1	LOCK SHAFT	4140	Ø1/2 X 2-1/8



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S090251



Part: C10-4-11

Job No: 176089

Serial No/Batch: S090251

Revision: 2A

Inspector:

Exp Date:

Instructions:

Date: 07/10/18